

Work Order ID 67680

Tuesday, March 29, 2011 11:19:06 AM



Page 1

Item ID: D1049

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 3/29/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-03-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D1049

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut Blanks: 2.000" long

*ent 11/04/01**20*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio FA217 & Dwg D1049
2-Debur*ent 11/04/06**21*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ent 11/04/06**21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/04/06		21	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				21	BR	11-4-6	
150 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QS1005 4.3 M 115128 Memo START TIME: 10:15 OVEN TEMPERATURE: 320 FINISH TIME: 10:45	0.00 0.00				2	BR	11-4-7	

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Page 3

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Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				21	0	21	21
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							21
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/4/11

MF

11-04-11

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:19:13 AM

Page 1

Work Order ID: 67680

Parent Item: D1049

Parent Item Name: Saddle



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevC 02.04.10 Re-format NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	19.8000	0.1666	3.507368			



6061-T6 Bar .750 x .250

Location

Loc Qty

Loc Code

MAT003

19.8

114968

19.8

3.508 cm 11/04/01

W/O:		WORK ORDER CHANGES					
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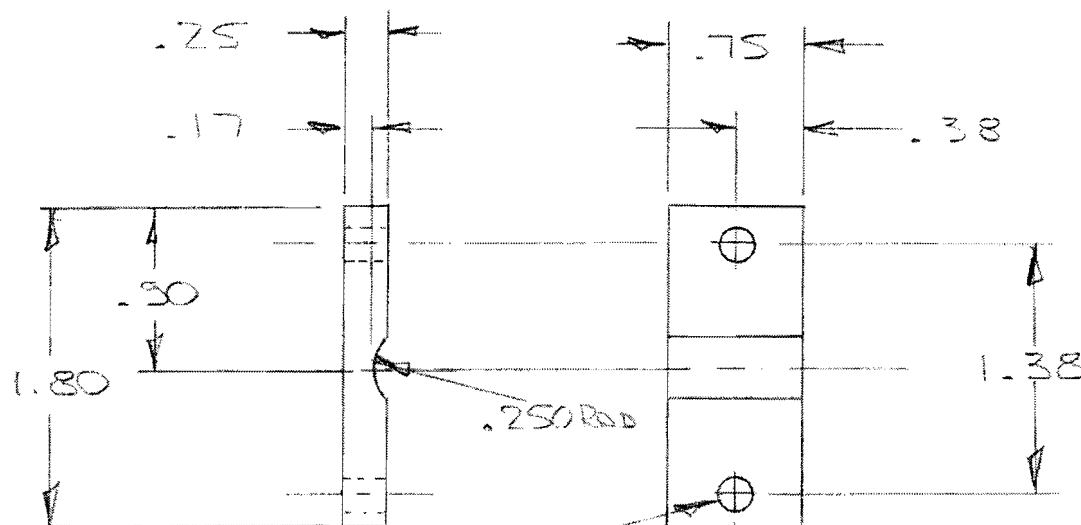
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NOTE: Date & initial all entries

RELEASED
97/08/02 Bw

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67480

11-03-29



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DA. DASH NO. W-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D-DRAWING D-DRAWING NO. OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTFIELD	DRAWN	DATE			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN	DATE	TITLE		
	GENERAL	LIMITS	B-M-M-S-P-O-M-T-O-A-D B-B-M-S-T-O-M-T-E-A-D		STRESS		SADDLE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER NAS 1-18-17-1 5. HOLES PER AND 10097	1. TOLERANCES — .004 & .030 2. ANGLES 1/2" 1/16" 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005			CHECKED		CODE	DWG NO.	REV
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CLERK		D1049		
					SCALE		1:1	SHT	OF

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